

Amendments to the Specification

Please replace the paragraph on page 9, beginning line 27 and bridging page 10, with the following amended paragraph:

--A first exemplary embodiment, according to the invention, of an internal broach according to Figs. 3 to 5 comprises broach cutting teeth 21, a first tooth of which being designated by 21a, further teeth by 21b, 21c, 21d, 21e, and a last tooth by 21f. Even if only a total of six broach cutting teeth 21 are illustrated, at least five to twenty times the number of teeth - depending on the depth of profile to be produced - are available in practice in the broaching portion 4 of a broach. The broach cutting teeth 21a to 21f are arranged on the broach counter to the direction of broaching 22. The broach cutting teeth 21a to 21f each have a bottom cutting blade 23a to 23f, called primary blade in practice, which extends in the course of a circle that is concentric of the axis 11. For example, Fig. 2 shows cutting blade 23f extending as an arc of circle X. The bottom cutting blades 23a to 23f are customarily provided with a relief produced by grinding i.e., a relief angle. They have a bottom cutting blade relief surface 24 and a machining surface 25, as seen in Figs. 4 and 5.--

Please replace the paragraph on page 10, beginning line 13, with the following amended paragraph:

--The sides of the broach cutting teeth 21 that are allocated to the flanks 15, 16 of the work piece 8, which are to be produced, vary in design. The sides of the broach cutting teeth 21a to 21f ~~that~~ lie in a single curved plane Y as shown in Fig. 3 and are allocated to a flank 15 - on the left in Fig. 3- are pure guide flanks 26a to 26f. Over the

full flank height, their course corresponds to the course of the flank 15 that is to be produced. ~~The~~ They do not possess a relief produced by grinding or a relief angle i.e., they are not designed as a relief surface as seen in Fig. 5, and are not relieved in position as seen in Fig. 5. The pitch a between the teeth as shown in Fig. 3 is in the range of 10 to 80 μm . The guide edge 27a to 27f between the respective guide flank 26a to 26c and the machining surface 25 is a non-cutting edge 27a to 27f without cutting ability.--